

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011971**Date Inspected:** 09-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** NA**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Outside Yard:

- This QA inspector performed in process visual Inspection of the below mentioned fillet welds between Floor Beam and Floor Beam Flange.

SEG 9BW:

- 1) PP74-FB011-023 - 003.
- 2) PP74-FB003-136 – 004.

SEG 9BE:

- 1) PP76-FB028-007 – 093.

- The above mentioned welds were previously Magnetic Particle Testing (MT) tested and accepted by ZPMC Quality Control (QC) personnel. As per contract documents, ZPMC QC is required to perform 25% MT of these welds.

- Visually, above mentioned welds on SEG 9BW appeared to comply with the contract documents.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

- The member(s) are identified as OBG components – Floor Beam & Floor Beam Flange.

- The following weld did not appear to comply with the applicable contract documents:

SEG 9BE:

1) PP76-FB028-007 – 093.

- During inprocess visual inspection of the above mentioned weld, this QA observed One (1) longitudinal indication.

- This was confirmed with MT wherein, One (1) longitudinal crack measuring approximately 33mm length was observed.

- The above mentioned weld was previously Magnetic Particle Testing (MT) tested and accepted by ZPMC Quality Control (QC) personnel.

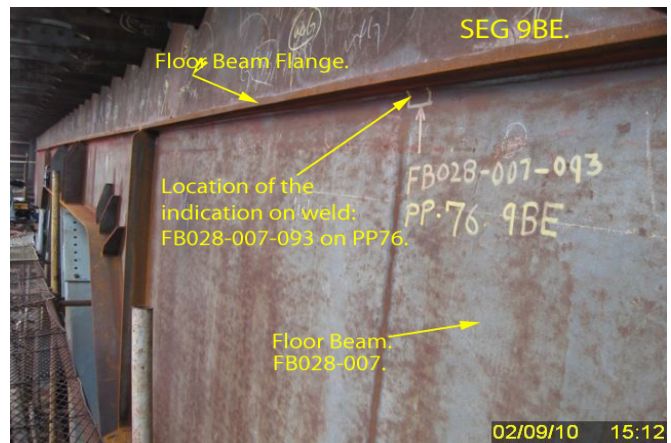
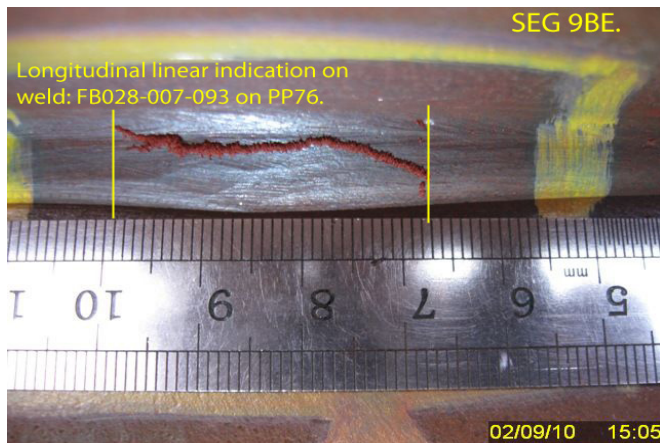
- The member(s) are identified as OBG components – Floor Beam & Floor Beam Flange on PP76.

- This QA Inspector has generated MT report for this date.

- This QA Inspector had informed American Bridge Fluor (ABF) QA identified as Mr. Peter Shaw & ZPMC QA identified as Mr. Zhong Wei, of this issue and that an incident report would be generated.

- For further information, please see the attached photos.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Reviewed By: Hall,Steven

QA Reviewer